

# Injection Molding of PULSE™ 2100LG PC/ABS Engineering Resin

## Drying Recommendations

**Moisture Content:** It is recommended to dry this resin to less than 0.02% moisture.

**Dryer:** A desiccant-type dryer is recommended for this material.

**Dew Point:** -20°F (-30°C) or lower is desired.

**Drying Time:** A minimum of 4 hours at 220°F (104 °C), or overnight at 180-210°F (82-93°C).

## Equipment Specifications

**Shot Size:** As required to fill part.

**Clamp Tonnage:** 2.5-3.0 tons/in<sup>2</sup> (0.35-0.42 tonnes/cm<sup>2</sup>) of projected surface area.

**Barrel Capacity:** 60-70% of machine barrel size should be for part shot.

## Process Conditions

**Melt Temperature:** Can be varied as required to fill part. See Table 1.

**Mold Temperature:** Can be changed to affect gloss or demolding characteristics. See Table 1.

**Manifold/Drop Temperature:** 20-40°F (11-22°C) below melt temperature. See Table 1 for recommended melt temperatures and adjust manifold/drop temperature accordingly.

**Purging/Shutdown:** For short interruptions in production, empty the barrel and reduce barrel temperatures. For extended shutdowns, purge the machine with a purging compound or general purpose polystyrene before shutting down machine.

**Table 1:** Machine Temperature Recommendations

Temperatures	Range, °F (°C)	Aim, °F (°C)
Melt Temperature	525-575 (274-302)	550 (288)
Mold Temperature	160-200 (71-93)	180 (82)
Barrel – Feed	480-520 (249-271)	490 (254)
Barrel – Transition	500-540 (260-282)	525 (274)
Barrel – Metering	530-570 (277-299)	545 (285)
Nozzle	520-550 (271-288)	530 (277)

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.